

Date: Friday, 30/05/2008 10:12:34 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FLOOR PROTCTOR RH		
Job Number	: 39596		Part Number	: D32803		
Estimate Number	: 11225		Drawing Number	: D3280 REV.D		
P.O. Number	:		Project Number	: N/A		
This Issue	: 30/05/2008	S.O. No.	Drawing Revision	: D		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	: THERMOFORMING			
Previous Run	: 37782		Due Date	: 10/06/2008		Qty: 10 Um: Each
Written By	:					
Checked & Approved By	: <u>JUL 08.5.30</u>					
Comment	: Est Rev:A 04.07.01 New issue KJ/JLM Est RevB 07.09.12 Thermoform in house DL Est Rev C 08.03.11 Dwg. Rev Change. DL EST Rev D 08.04.15 Material Change DL					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MLEXS093F600602	GE PLASTICS LEXAN SHEET
		 Comment: Qty.: 4.3330 sf(s)/Unit Total : 43.3300 sf(s) GE PLASTICS LEXAN SHEET
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
		 Material Batch Number <u>M 106751</u> <u>BB 08/02/06</u> <u>(Ph)</u>
3.0	THERMOFORMING	THERMOFORMING MACHINE
		 Comment: HAND FINISHING THERMOFORMING <u>BB 08/02/06 X10 (70)</u>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <u>BB 08/02/06 X70 (70)</u>
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3280-3 PAR #: 11A Fault Category: Prod / thermal forming NCR: Yes No DQA: D Date: 08/06/09
 QA: N/C Closed: D Date: 08/06/09

NCR: 39596		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/06/09	# 2.0	one part Part scrap sheet overheated. PC oven stuck over the part.	/ JSLH	Scrap and destroy NO replace QTY (X)	D 08/06/09	08/06/09	/	S 08/06/09

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTCTOR RH

Job Number: 39596

Part Number: D32803

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB

08/06/03

XO. (X9)

6.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

- 1) Check Surface finish for undesired marks, voids, dimples etc.
- 2) Check dimensions to ensure conformity to drawing tolerances.

BB

08/06/03. (X9)

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/05 (X9)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

8/6/5

(X9)
SP

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/09 (X9)

Job Completion



MF 08-06-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39596
Description: R22 Floor Protector, RH	Part Number:	D3280-3
Inspection Dwg: D3280 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: *BB*

Date: 08/06/03

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.3	+/-0.100	18.35	✓			
15.8	+/-0.100	15.82	✓			
12.1	+/-0.100	12.1	✓			
0.95	+/-0.030	.95	✓			
0.25	+/-0.030	.258	✓			
0.070	Min	.76	✓			
0.050	Min	.69	✓			

Measured by: *BB*

Date: 08/06/03

Audited by: *BB*

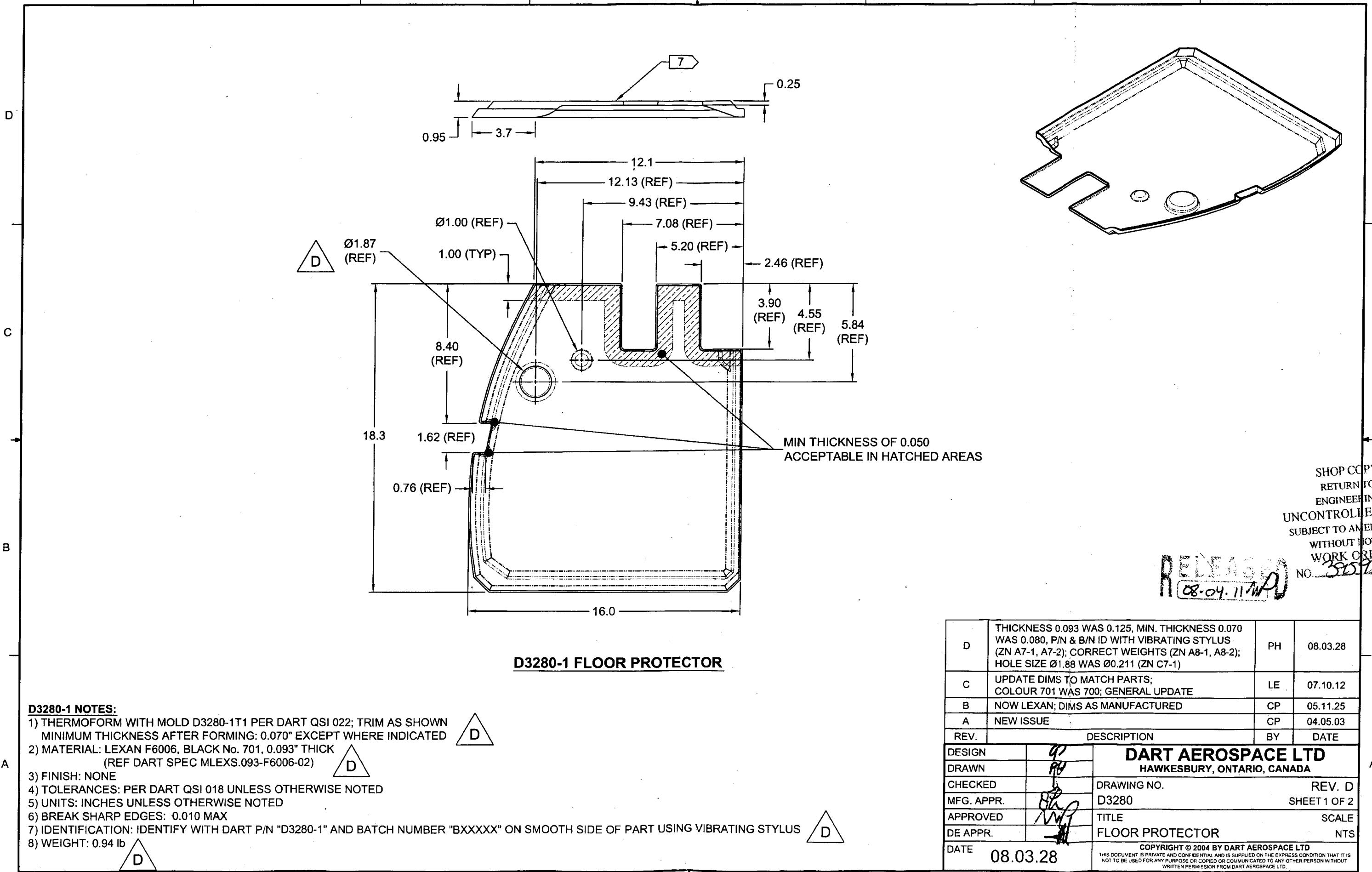
Date: 08/06/03

Prototype Approval: N/A

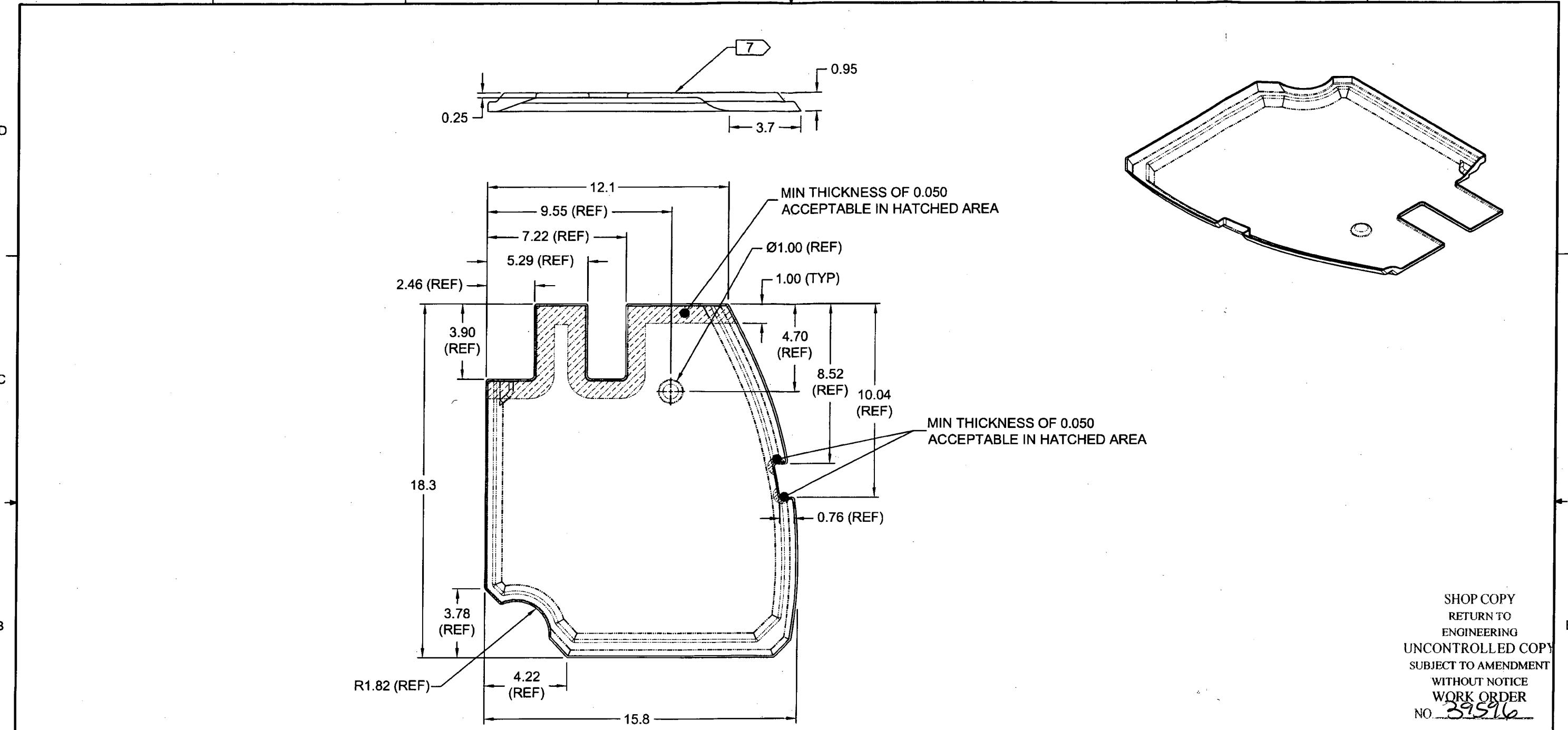
Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	<i>BB</i>

8 7 6 5 4 3 2 1



REV.	DESCRIPTION	BY	DATE
D	THICKNESS 0.093 WAS 0.125, MIN. THICKNESS 0.070 WAS 0.080, P/N & B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2); CORRECT WEIGHTS (ZN A8-1, A8-2); HOLE SIZE Ø1.88 WAS Ø0.211 (ZN C7-1)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS; COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.12
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3280	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
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D3280-3 FLOOR PROTECTOR

D3280-3 NOTES:

1) THERMOFORM WITH MOLD D3280-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED

2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)

3) FINISH: NONE

4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.010 MAX

7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3280-3" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS

8) WEIGHT: 0.88 lb



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NO. 35516

08-01-11 M.D.

DESIGN	<i>QP</i>	DART AEROSPACE LTD	
DRAWN	<i>Rey</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>J.S.</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>BHP</i>	D3280	SHEET 2 OF 2
APPROVED	<i>TW</i>	TITLE	SCALE
DE APPR.	<i>TW</i>	FLOOR PROTECTOR	NTS
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